Qty:

Each

20 Um:

.Date:

Thursday, 1.1/09/2008 10:42:13 AM

User:

Júlie Lecocq

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

304/316 0.125 Sheet

Drawing Number

Project Number

Drawing Revision

: DOUBLER

: D32861

: N/A

: D3286 REV A

: 30/09/2008

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41978

Estimate Number

: 10892

P.O. Number

This Issue

: 11/09/2008 : NC

Prsht Rev. First Issue

: //

Type

S.O. No. :

: SMALL /MED FAB

: 40437 Previous Run

Written By

Checked & Approved By

Comment

New issue KJ/JLM

Est Rev:B Now on Waterjet 06-06-16 JLM

Additional Product

Job Number:



Seq. #:

2.0

Machine Or Operation:

1.0 M304S11GA

Comment: Qty.:

0.0786 sf(s)/Unit

Total:

1.5729 sf(s)

304/316 .125 Sheet

Batch: 108156

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3286

Dwg Rev:_ ♣

Prog Rev: A

2-Deburr if necessary

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3286

Page 1

Form: rprocess

N/O:		R CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-						
						1	
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
	Resolution: _	Disposition:	QA: N/C (Closed:		Date: _	

NCR:	į.	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Ammanual	Approval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspecto	
				,					
						,			
						ţ			
								}	

NOTE: Date & initial all entries

Thursday, 11/09/2008 10:42:13 AM-Date: User: Julie Lecoca

Process Sheet

Drawing Name: DOUBLER

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 41978

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

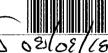
Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP





622

Comment: INSPECT WORK TO CURRENT STEP 7.0



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Jamie



8.0 QC21



INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mr 68-69-19

Dart Ae	rospace L	Lla							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						м			
						*			
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:	r de la companya de l			ER NON-CONFORMA!	NCE (NCF	₹)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	B Sign 8		cation ion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	0000		Office Ling	do moposis.
					}				
								l.	
				•					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41918
Description: Doubler	Part Number:	D3286-1
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	X First Article			Prototype	
Drawing	Tolerance	Actual	Accept	Reject	Method Inspect	
Dimension	loierance	Dimension	Accept	- Acject		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
					•	
5.374	+/-0.010	5,384	A.			
3.974	+/-0.010	3,977	*			
2.000	+/-0.010	2.006	*			
1.000	+/-0.010	1.009	×			
0.700	+/-0.010		*			
Ø0.188	+0.005/-0.001	,188	æ			
0.125	+/-0.010	118	*			
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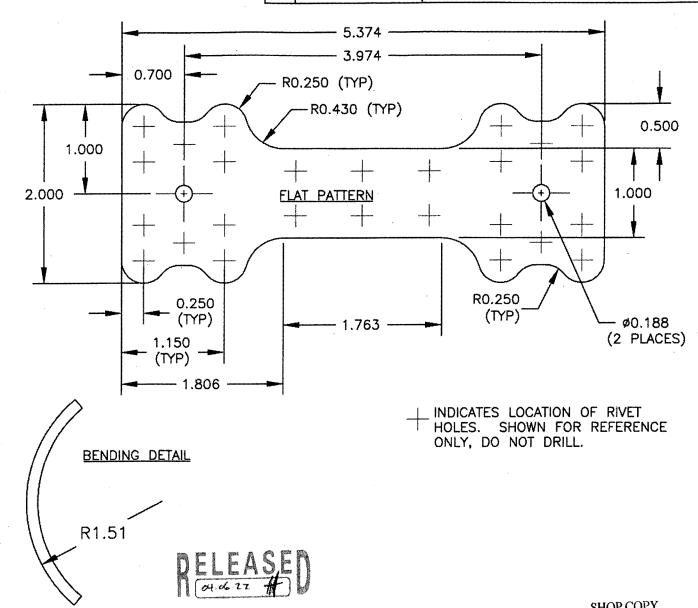
Measured by:	HB.	Audited by:	2	Prototype Approval:	N/A
Date:	8-9-11	Date:	odouls	Date:	N/A

Rev	Date	Change	Revised by KJ/JLM	Approved
Α	06.11.07	New Issue	KJ/JLM	8





DESIG	R	DRAWN BY	DART AEROSPACE	
CHEC	ŒĎ,	APPROVED	DRAWING NO.	REV. A
	#-	#r	D3286	SHEET 1 OF 2
DATE			TITLE	SCALE
04.0	5.06		GROUND HANDLING PARTS	1:1
Α		04.05.06	NEW ISSUE	



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

2) BREAK ALL SHARP EDGES 0.010 TO 0.020 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

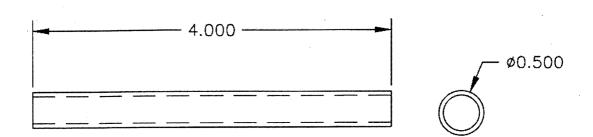
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DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		C.
CHECKED,	APPROVED,	DRAWING NO.			REV. A
H	-₩	D3286		SHEET :	2 OF 2
DATE	· · · · · · · · · · · · · · · · · · ·	TITLE			SCALE
04.05.06	•	GROUND I	HANDLING PARTS		1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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